

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012051**Date Inspected:** 19-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Liu Zhong An**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**BAY 11 STRUT FLANGE PLATE**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ED1-STSA4-6-131M-2-7A/B, 8A/B

ND1-STSA4-6-131M-1-7A/B, 8A/B

ND1-STSA4-6-131M-2-7A/B, 8A/B

ND1-STSA4-6-123M-2-7A/B, 8A/B

ED1-STSA4-6-127M-1-7A/B, 8A/B

ED1-STSA4-6-127M-2-7A/B, 8A/B

**TOWER ASSEMBLY AREA**

This QA inspector was instructed by task leader to carry out the measurements on the Strut plates for flange to

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## WELDING INSPECTION REPORT

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flange, bolt hole distance, stiffener to stiffener distance, 10mm to CJP. The measurements carried out wherever accessible and recorded on the data sheet and submitted to the task leader. The members are identified as Tower Components. The member designations reviewed are as follows.

ND1-A476-47.6M-2

WD1-A476-47.6M-1

WD1-A467-43M-4

WD1-A467-43M-3

WD1-A467-43M-2

WD1-A467-43M-1

ND1-A468-43M-2

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 11

### STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1A located on ED1-SA4-68-123M-2.

Welder is identified as 040611. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 1A located on ND1-SA4-68-131M-1.

Welder is identified as 040669. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

BAY 10

### SOUTH TOWER LIFT 5 A/E CORNER SEAM

SMAW welding of weld joint 36B located on SSD1-TL5-1B/F.

Welder is identified as 040365. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

### SOUTH TOWER LIFT 5 A/B CORNER SEAM

SMAW welding of weld joint 37B located on SSD1-TL5-1B/F.

Welder is identified as 057258. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-B-U3b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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